

Date: Tuesday, 05/05/2009 12:56:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COVER
Job Number : 47735	
Estimate Number : 13917	
P.O. Number :	Part Number : D39391
This Issue : 05/05/2009 S.O. No. :	Drawing Number : D3939 PREL
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PREL
Previous Run :	Material :
Written By :	Due Date : 12/05/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JD 09.05.05</u>	
Comment : Est Rev:A 09.05.04 new issue EC verified by:DD	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.0656 sf(s)/Unit Total : 0.3938 sf(s)
 6061-T6 .050 Sheet
 batch: 110791 1B9-5-5

Material cuts

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3939
 Dwg Rev: PRE
 Prog Rev: Liv 1B9-5-5
 2-Deburr if necessary 1B9-5-5

(9)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ENGINEERING
 APPROVAL 09/05/14

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

JD

05-05-06

(29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 12:56:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 47735

Part Number: D39391

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



⑨

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 07-05-8

7.0

PACKAGING 1

PACKAGING RESOURCE #1



9X

Comment: PACKAGING RESOURCE #1

Identify with Dart part # using yellow paint marker and Stock

Location: _____

I

SENT TO H. SIEMENS
@ EAGLE

alsk

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-08

POSITIVE RECALL
EFFECTIVE 09-05-08 AUTH L
RELEASED 14 DATE 09/05/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47735
Description: COVER		Part Number: D3939-1
Inspection Dwg: D3939-1 Rev: PREL		Page 1 of 1

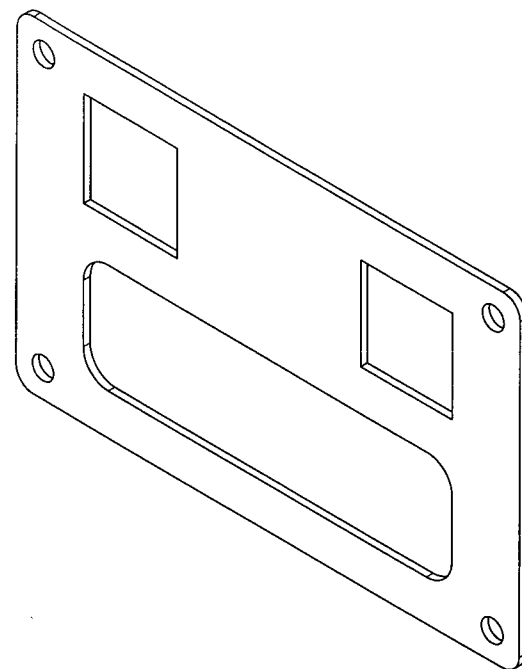
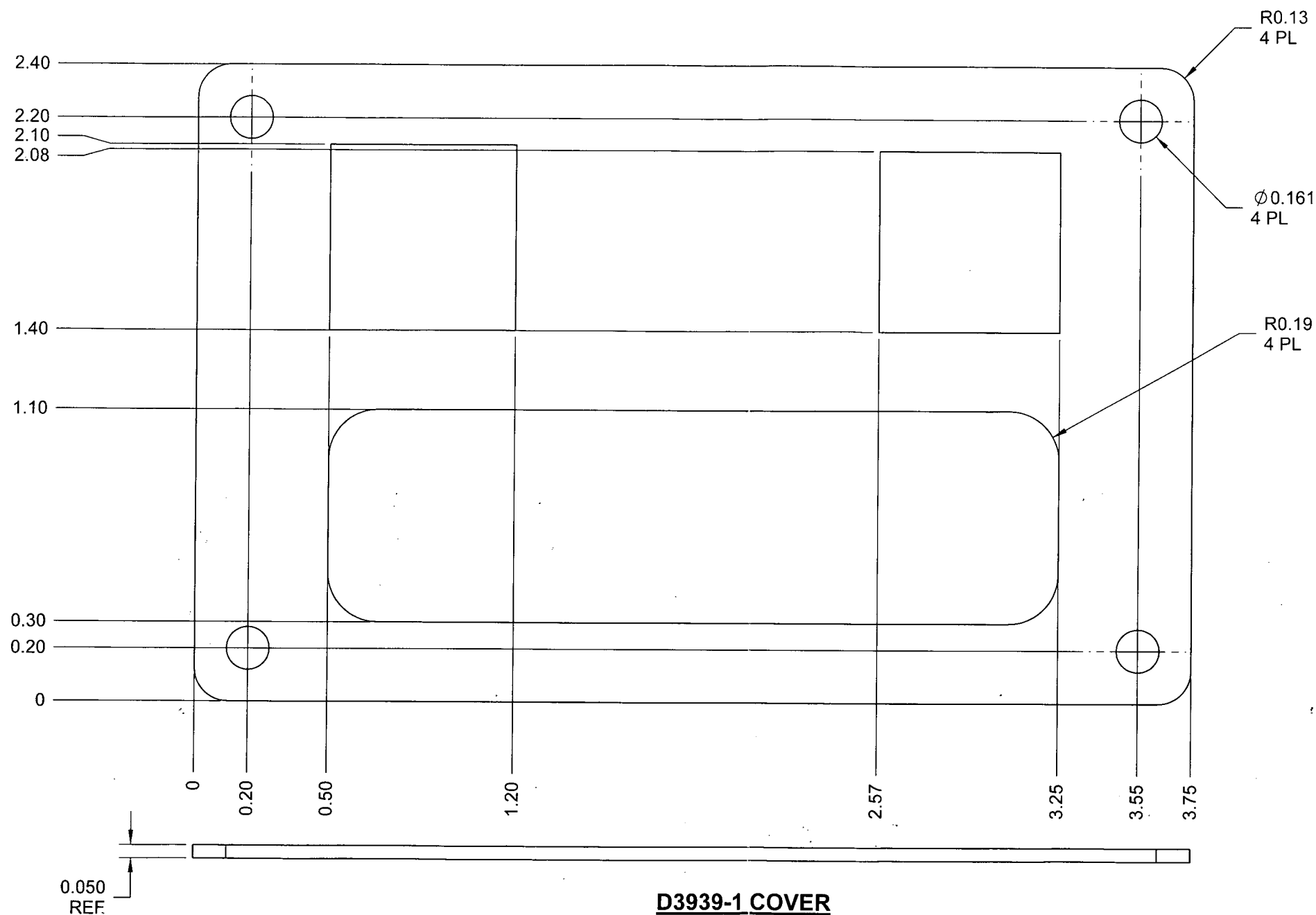
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype Prelim.

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .161	+ .006 - .001					
.70	± .030	.701	X			
.150	± .030	.1501	X			
1.20	± .030	1.188	X			
2.57	± .030	2.553	X			
3.25	± .030	3.256	X			
3.55	± .030	3.551	X			
3.75	± .030	3.756	X			
.20	± .030	.201	X			
.30	± .030	.302	X			
1.10	± .030	1.105	X			
1.40	± .030	1.400	X			
2.08	± .030	2.083	X			
2.10	± .030	2.101	X			
2.20	± .030	2.200	X			
2.40	± .030	2.405	X			
.050	± .010	.047	X			

Measured by: IB	Audited by: [Signature]	Prototype Approval:
Date: 9-5-8	Date: 10/05/08	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47735

PRELIMINARY ISSUE
09/05/04 JWP

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3939-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.03 lbs

A	NEW ISSUE	BY	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D3939	SHEET 1 OF 2
TITLE COVER	SCALE NTS

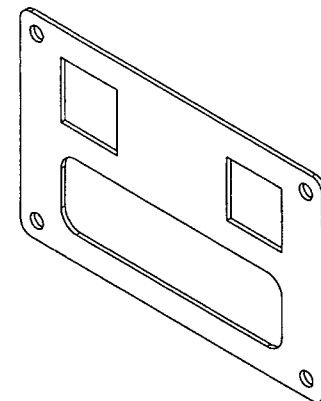
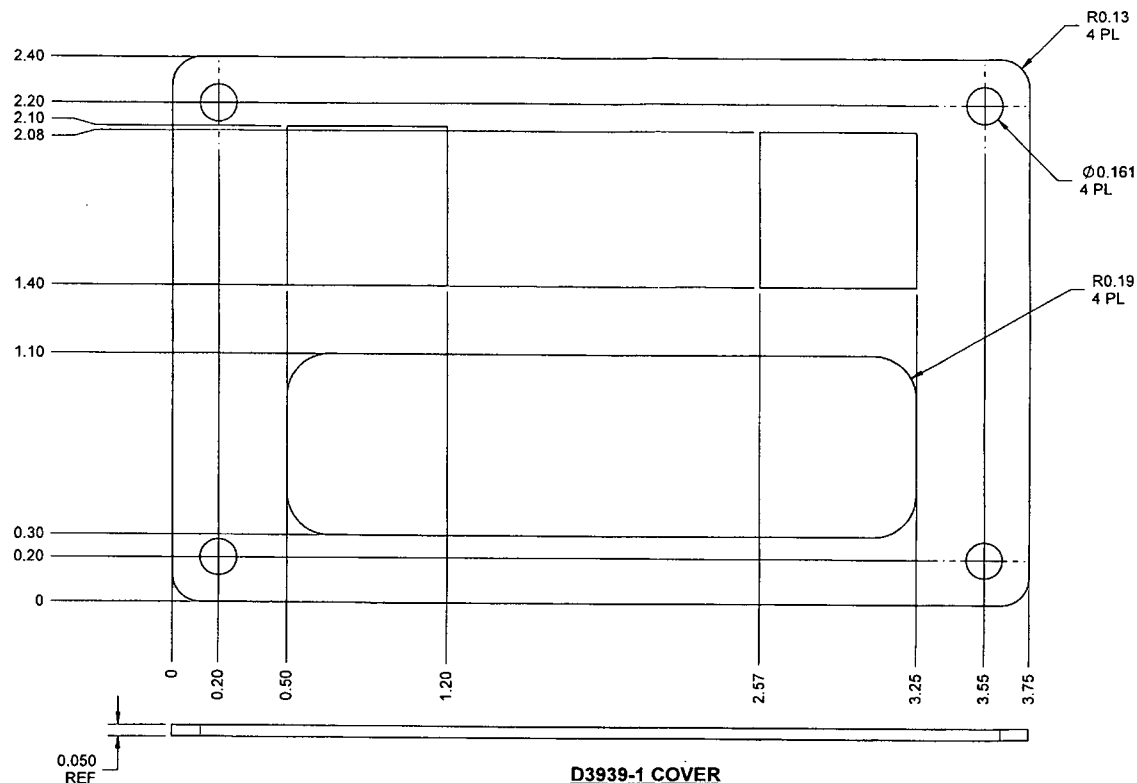
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8 7 6 5 4 3 2 1

D

C

B



RELEASED
-05-14-2009

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47735

A		NEW ISSUE		BY		DATE	
REV.		DESCRIPTION					
DESIGN							
DRAWN							
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.							
DATE							

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3939
REV. A
SHEET 1 OF 2
TITLE COVER
SCALE NTS

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